

METHODS OF SAMPLING AND TESTING
MT 418-04
METHOD OF ACCEPTANCE FOR MISCELLANEOUS WELDED ITEMS
(MONTANA METHOD)

1 Scope:

- 1.1** This method is intended as a guide for the acceptance of miscellaneous, low stress carrying welded items. It does not cover any welding in connection with bridge related items.

2 Referenced Documents:

- 2.1** Montana Department of Transportation Detailed Drawings

3 Field Welding Acceptance:

- 3.1** The low stress carrying members listed in 3.1.1, 3.1.2, and 3.1.3 below can be approved by the field provided the welding has been done by a qualified welder in accordance with AWS D1.1 Current edition, Limited Thickness. In the event that field welding is necessary, contact the Bridge Bureau for welder qualification tests.

- 3.1.1** Trash guard racks (MDT Detailed Drawing No. 615-02) and median inlet covers (MDT Detailed Drawing No. 604-00).

- 3.1.2** Guardrail terminal section anchor plates (MDT Detailed Drawing No. 606-86).

- 3.1.3** Ladders, stairways, scale pit angles, grates, and miscellaneous items associated with weigh stations, rest areas, and observation points.

3 Acceptance Procedure:

- 4.1** The procedure listed in 4.1.1, 4.1.2, 4.1.3, and 4.1.4 below must be followed for the acceptance of welded items covered in this method.

- 4.1.1** A copy of the mill test results must accompany the material.

- 4.1.2** A copy of the welder qualification form or other verification must accompany the material.

- 4.1.3** The items must be visually inspected and the welds examined for appearance, size, undercut, and porosity.

- 4.1.4** Items 4.1.1 and 4.1.2 must be attached to the visual inspection report and submitted in the usual manner.